

Work Order ID 51196

August 6, 2009 2:23:32 PM



Page 1

Item ID: D3789-7

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clamp

Start Date: 8/10/09

Start Qty: 12.00



Cust Item ID:

Required Date: 8/14/09

Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3789

Rev A

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

Cut extrusion to .820"

0.00

DJP 09/08/10

13

0

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per Folio FA834

Dwg Rev: *A*

Folio Rev: *AA*

0.00

ent 09/08/11

13

0

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 51196

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Page 2

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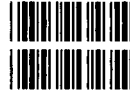
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Start Qty: 12.00



Cust Item ID:

Required Date: 8/14/09

Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

115

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

OK 09/08/11

13

0

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

M.A 09/08/12

13

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11 09/08/12

13

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo M112260
 *****Mask bearing bore prior to powder coat*****
 START TIME: 1:00pm
 OVENTEMPERATURE: 320°F
 FINISH TIME: 1:30pm

0.00

160 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> 8/10/09

(X13)

= 09-08-12 (X13) HJ

=> 8/10/09

(X13) f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Item Name: Clamp

Start Date: 8/10/09 Start Qty: 12.00



Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Identify as per dwg & Stock Location: <u>467</u>	0.00							
Packaging Packaging	Memo	0.00				13			MD 09/08/13
200 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							09-08-13 WLF 09-08-13

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 1/1

August 6, 2009 2:23:31 PM

Work Order ID: 51196



Parent Item: D3789-7RevA



Parent Item Name: Clamp

Start Date: 8/10/09

Required Date: 8/14/09

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2423RevB1

Manufactured

No

100

f

760.9447

0.8842



Lug Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

760.94468

43722

213.01468

44529

22.39

45800

525.54

DJP 09/08/10

~~0.8842~~ .9324

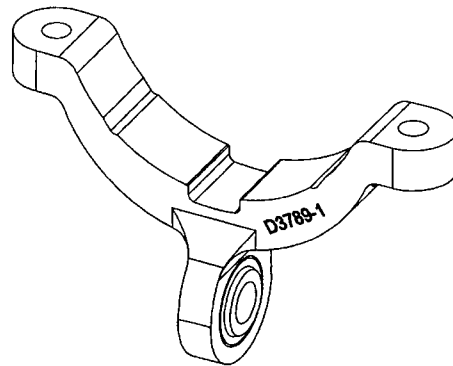
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

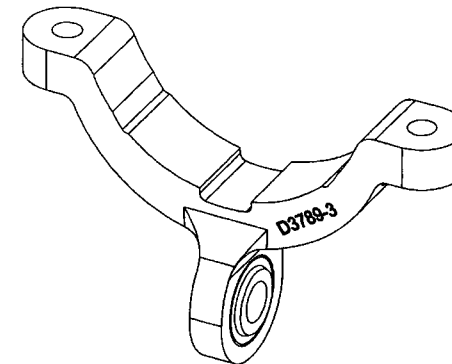
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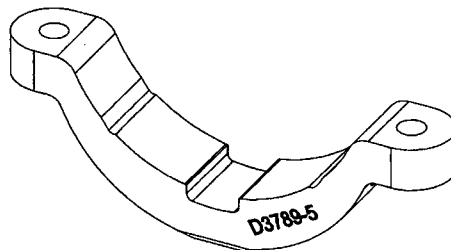
NOTE: Date & initial all entries



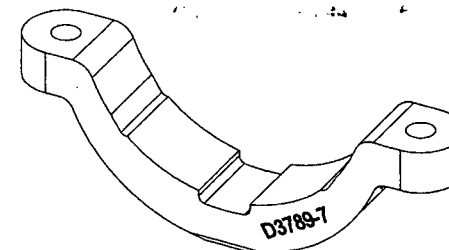
D3789-1 CLAMP



D3789-3 CLAMP



D3789-5 CLAMP



D3789-7 CLAMP

*WLO
5496*

DEO ATTACHED

RELEASED
08/12/21

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N AS SHOWN
- 7) WEIGHT: D3789-1, 0.16 lbs
D3789-3, 0.16 lbs
D3789-5, 0.14 lbs
D3789-7, 0.14 lbs
- 8) STAKE D2611 BEARING 4 PLACES EACH SIDE AFTER POWDER COAT
- 9) PART IS SYMETRICAL ABOUT ϕ

A		NEW ISSUE		HS	08.05.21
REV.		DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3789 CLAMP			REV. A
DRAWN	HS				SHEET 1 OF 5
CHECKED					SCALE
MFG. APPR.					NTS
APPROVED					
DE APPR.		DATE 08.05.21		<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

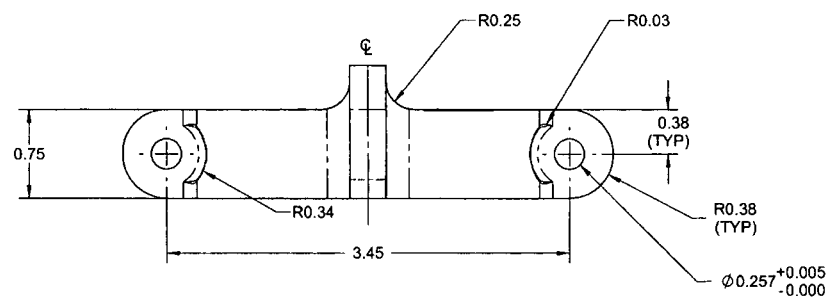
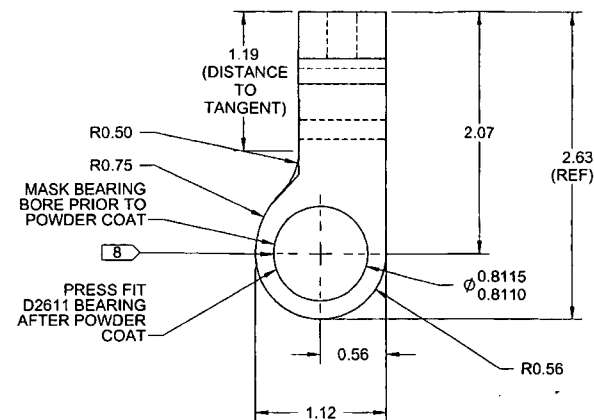
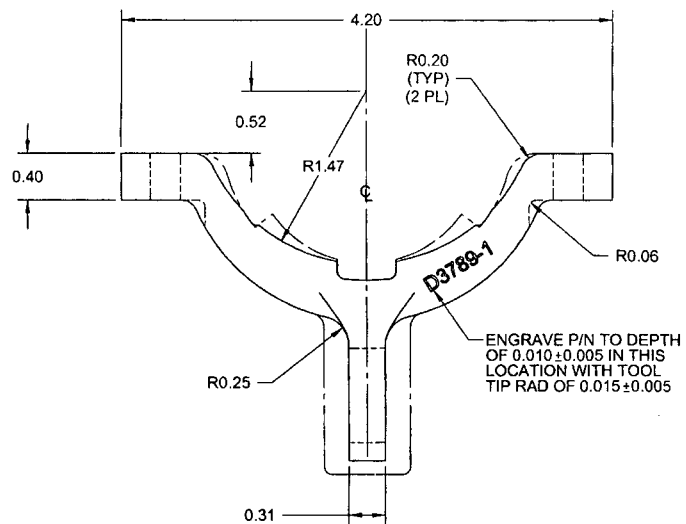
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NOTE: Date & initial all entries



D3789-1 CLAMP

W/O 51196

DEO ATTACHED

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08/12/21

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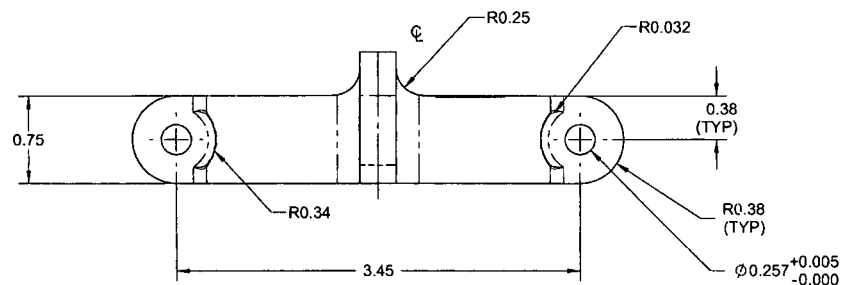
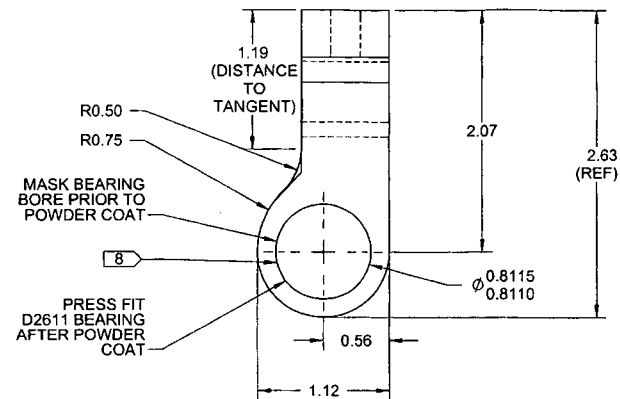
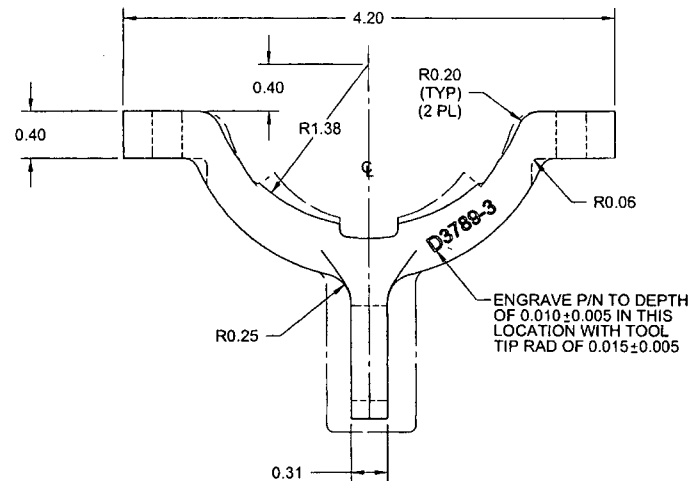
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D3789-3 CLAMP

W10 51196

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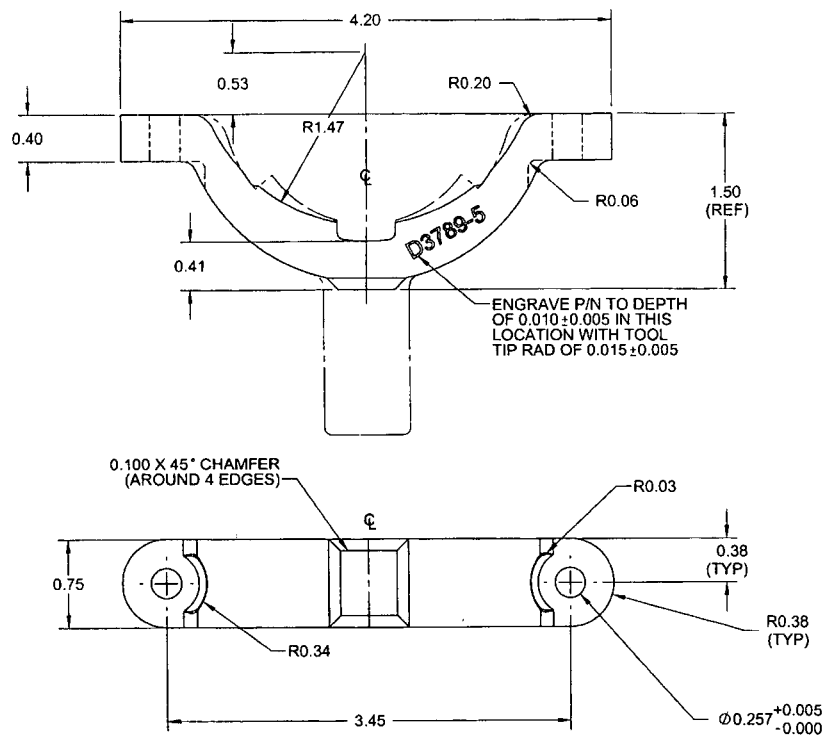
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3789-5 CLAMP

W10 51196

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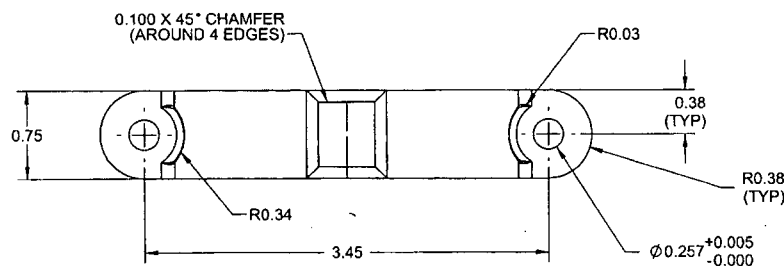
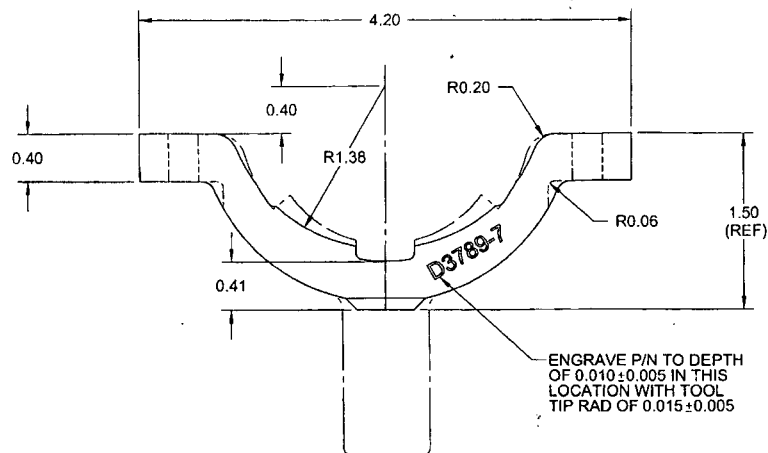
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D3789-7 CLAMP

W10 51196

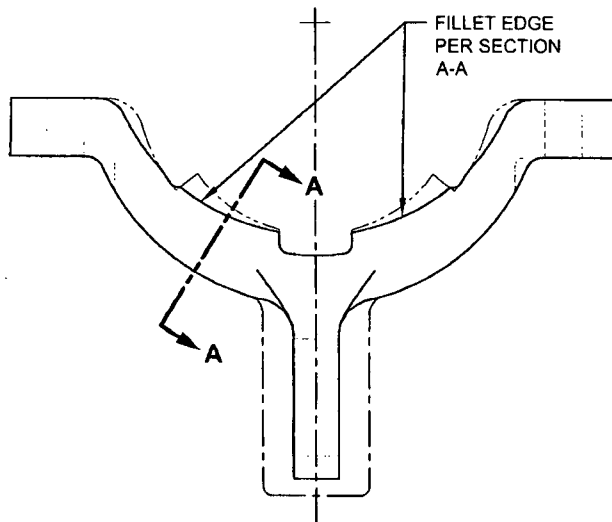
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DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO. D3789	REV. A
MFG. APPR.			SHEET 5 OF 5
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DE APPR.			NTS
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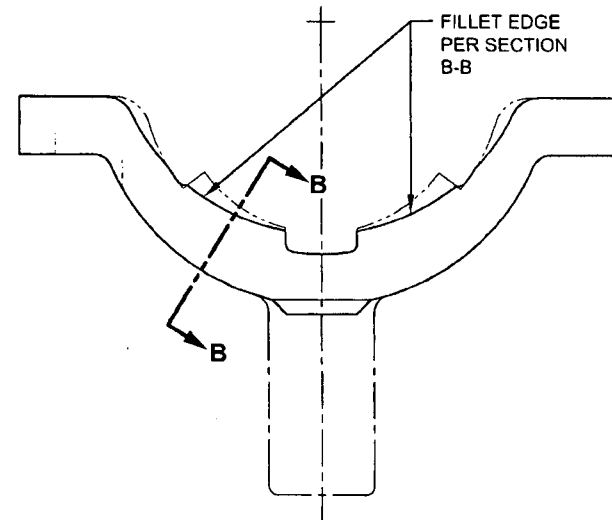
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DRAWN AJS	CHECKED [Signature]	MFG. APPR. [Signature]	APPROVED [Signature]		DE APPR. [Signature]		
DATE 09.04.20	DATE 09.04.23	DATE 09.04.23	DATE 09/04/23		DATE 09/04/23		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3789-1 CLAMP

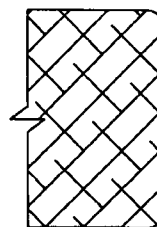
D3789-3 CLAMP



D3789-5 CLAMP

D3789-7 CLAMP

WRO 51196



R0.06 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/05/04 [Signature]

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DART AEROSPACE LTD		Work Order: 51196
Description: CLAMP		Part Number: D3789-7
Inspection Dwg: D3789 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	± 0.030	4.205	✓			
0.40	± 0.030	0.395	✓			
0.40	± 0.030	0.401	✓			
0.41	± 0.030	0.411	✓			
1.50	± 0.030	1.496	✓			
R0.06	± 0.030	0.062	✓			
R0.20	± 0.030	0.200	✓			
R1.38	± 0.030	1.38	✓			
0.75	± 0.030	0.747	✓			
R0.34	± 0.030	0.34	✓			
3.45	± 0.030	3.448	✓			
R0.03	± 0.030	0.03	✓			
0.38	± 0.030	0.376	✓			
R0.38	± 0.030	0.38	✓			
Ø0.257	+0.005/-0.000	0.258	✓			

Measured by: DJP	Audited by: M.A	Prototype Approval:	N/A
Date: 09/08/10	Date: 09/08/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	